

Date: Wednesday, 5/28/2008 8:37:00 AM  
 User: David Duval

## Process Sheet

OK

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : FRONT RAIL, RH  
 Job Number : 39531  
 Estimate Number : 13347  
 P.O. Number :  
 This Issue : 5/28/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : R&D MACHINED PARTS  
 Previous Run :  
 Written By : AA 08/05/28  
 Checked & Approved By :  
 Comment : Est Rev:A 08-05-27 new issue DD verified by:EC

Part Number : D37712  
 Drawing Number : D3771 PROTO  
 Project Number : IA0004  
 Drawing Revision : PROTO 08.05.27  
 Material :  
 Due Date : 6/4/2008 Qty: 1 Um: Each

*Accuracy A  
 D3766-2 # 08.06.05*

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W188	6061T6 TUBE 1.00 X .188W
	Comment: Qty.: 2.9313 f(s)/Unit Total : 2.9313 f(s) 6061T6 TUBE 1.00 X .188W batch: <u>M 104779</u>	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1- cut tube as per dwg D3771	
3.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP <u>08.05.28 (1)</u>	
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: 1- drill holes as per dwg D3771 2-Deburr holes and ends of tube as per dwg D3771	
5.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP <u>08.05.28</u>	

**ENGINEERING  
 APPROVAL**

Date: Wednesday, 5/28/2008 8:37:01 AM  
User: David Duval

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: FRONT RAIL, RH

Job Number: 39531

Part Number: D37712

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*PD*

080528

1

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PD* 06.05.28

8.0 PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*PD* 01.05.29

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*HA* 08.05.29 *Perry*

Job Completion



*Change to w/o  
# 00196*

*U 08.06.11*

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-769

Job #: 00196

Date: 08.05.27

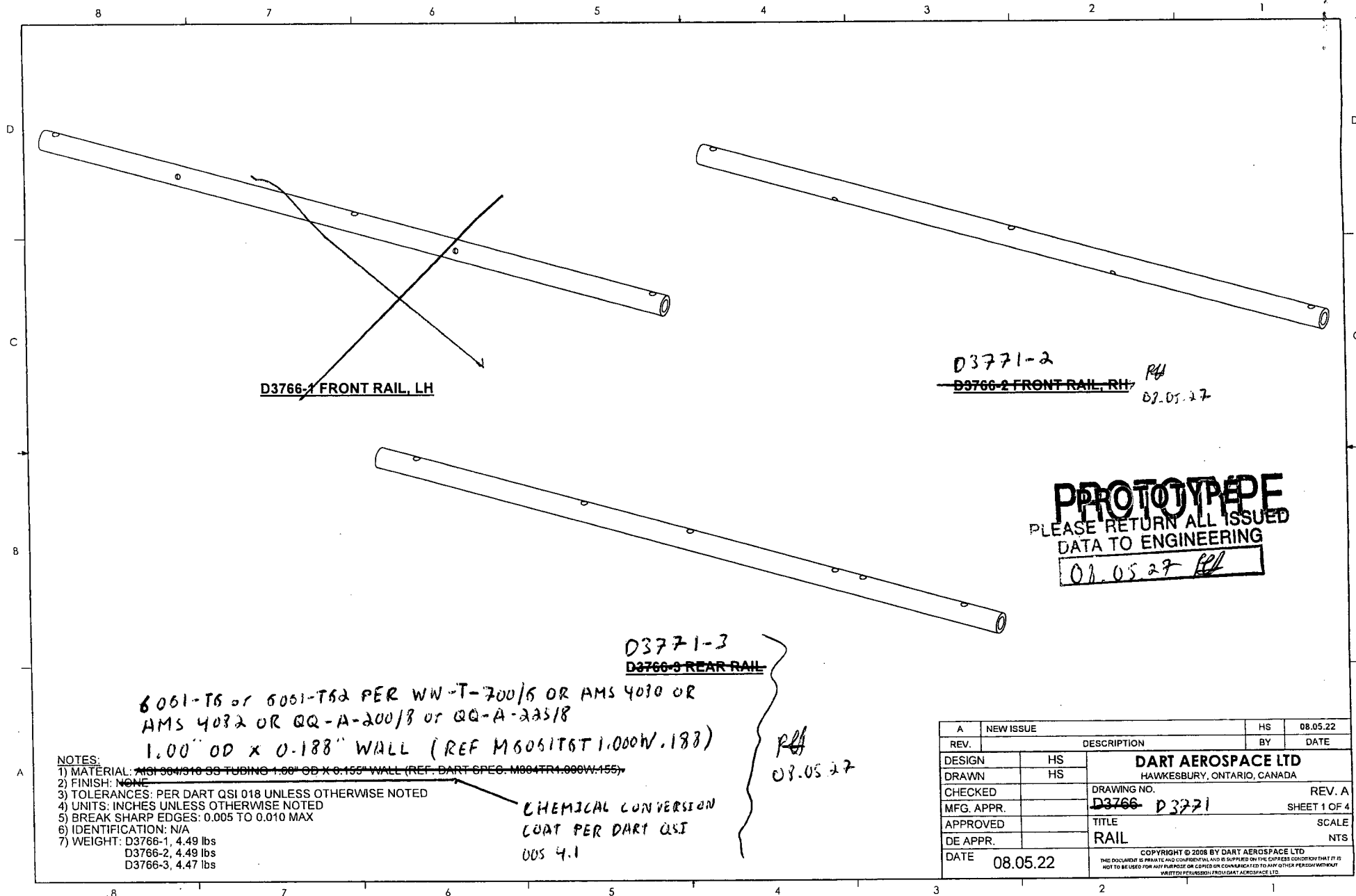
Product Name: Aft facing seat

Requested By: PH/HS

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3771-2	Front Rail, <del>LH</del> RH	08.05.22	Y	08.05.29	Aluminum Tubing	
1	D3771-3	Rear Rail	08.05.22	Y	08.05.29	Aluminum Tubing	

38874



D3766-1 FRONT RAIL, LH

D3771-2

D3766-2 FRONT RAIL, RH

PH  
08.05.27

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
08.05.27 PH

D3771-3  
D3766-3 REAR RAIL

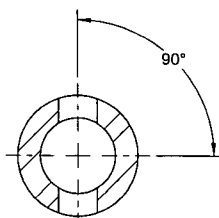
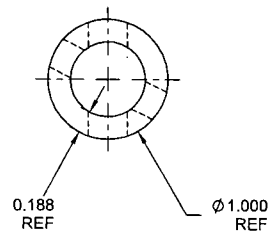
PH  
08.05.27

6061-T6 or 6061-T62 PER WW-T-700/6 OR AMS 4030 OR  
AMS 4032 OR QQ-A-200/8 or QQ-A-225/8  
1.00" OD x 0.188" WALL (REF M60516T1.000W.188)

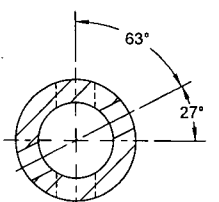
CHEMICAL CONVERSION  
COAT PER DART QSI  
UDS 4.1

- NOTES:
- 1) MATERIAL: ~~6061-T6~~ 6061-T62 PER WW-T-700/6 OR AMS 4030 OR AMS 4032 OR QQ-A-200/8 or QQ-A-225/8
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D3766-1, 4.49 lbs  
D3766-2, 4.49 lbs  
D3766-3, 4.47 lbs

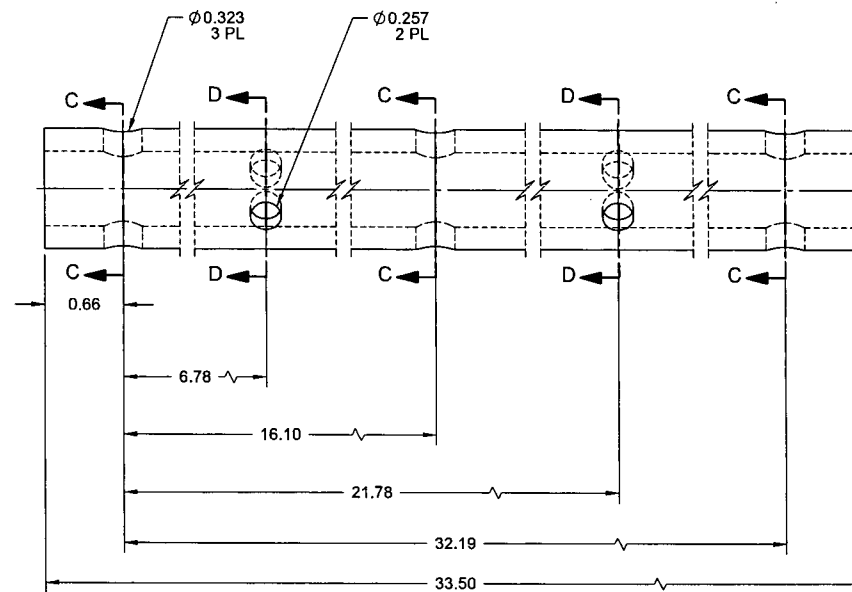
A NEW ISSUE		HS	08.05.22
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3766-3771	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RAIL	NTS
DATE	08.05.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**SECTION C-C**



**SECTION D-D**



**D3771-2**

**D3766-2 FRONT RAIL, RH**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
08.05.22 *PS*

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3766-2</b>	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RAIL	NTS
DATE	08.05.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

# Receiving Report

Date: 07/06/19 Batch No: M104779  
 Supplier: Camp Dart P/O: 3789  
 Packing Slip: Yes ☒ No ☐ Release Note Attached: Yes ☐ No ☐  
 Invoice: Yes ☐ No ☒ Waybill Attached: Yes ☐ No ☐  
 Receipt: Cash ☐ Cr ☒ Shipment Complete: Yes ☐ No ☐  
 QC6 Inspection: CR 07/06/19 N/A ☒ N/A ☐  
 Work Order: \_\_\_\_\_

Discrepancies	Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 \_\_\_\_\_

Location \_\_\_\_\_

Production/Admin: 07/06/20  
 Date: 07/06/20  
 Received/Costing: CR  
 Initial: \_\_\_\_\_

H:\FORMS\Purchasing\approved purchase report Rev D

50 377-4248  
 50 377-5696  
 MONTRÉAL : 514 336-4248  
 FAX : 514 336-4246  
 ONTARIO : 1 800 667-4248  
 FAX : 1 866 456-4242

DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS  
 STEEL AND SPECIALTY METALS DISTRIBUTOR

On a du Savoir "FER"

A / SHIP TO:  
 IVED JUL 03 2007  
 OSPACE LTD  
 RDEEN STREET  
 RY,

FACTURE INVOICE	N° 176053
DATE	19/06/07
BON DE LIVRAISON PACKING SLIP	N° 121607
DATE DE LIVRAISON DELIVERY DATE	19/06/07

TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
NET 30 JOURS	2R		001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
0 X .188	192	5.350		1027.20
CHARGE	1	0.000	UN	0.00

POIDS TOTAL 193.00  
 TOTAL WEIGHT

Formplus N° 8619

S REMAIN THE PROPERTY OF "ACIER CAMP" INC. UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.  
 BUYER'S EXPENSE. \* ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.  
 SPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY  
 1 MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. \* ANY DEFAULT IN RESPECT WITH  
 ENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE  
 \* ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. \* ANY MERCHANDISE  
 MODIFIED CANNOT BE RETURNED. \* ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE  
 GE.

ONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

SOUS-TOTAL SUB TOTAL	1027.20
T.P.S. G.S.T.	61.63
T.V.Q. Q.S.T.	0.00
<b>TOTAL</b>	<b>1088.83</b>

ENT / CUSTOMER'S SIGNATURE

DATE

*Frank E. Watson*

**CERTIFIED TEST REPORT**

CUSTOMER PO NUMBER: <b>60-27683</b>		CUSTOMER PART NUMBER: <b>ESRT733 1.188X24</b>		PRODUCT DESCRIPTION: <b>1.00 OD X .188 WALL</b>	
KAISER ORDER NUMBER: <b>993166</b>	LINE ITEM: <b>001</b>	SHIP DATE: <b>02/07/2007</b>	KAISER LOT NUMBER: <b>50924 036</b>	ALLOY: <b>6061</b>	TEMPER: <b>T6511</b>
WEIGHT SHIPPED: <b>1003.000 LB</b>	QUANTITY: <b>74.000 PCS</b>	B/L NUMBER: <b>936965</b>	DIAM/DA/TH/KNS:	WIDTH:	LENGTH: <b>24.000 FT</b>
SHIP TO: <b>MARMON-KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440-3060 USA</b>			SOLD TO: <b>MARMON-KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440-3060 USA</b>		

**Actual Physical Properties**

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	%Elong in 2	HARDNESS	CONDUCT	BEND
XTR058141	0001	001	45.5	41.5	26.3	NA	N/A	N/A
XTR058141	0001	002	44.9	40.4	23.6	NA	N/A	N/A
XTR058141	0001	003	42.3	38.1	23.1	NA	N/A	N/A

**Chemical Composition (wt%), Aluminum Remainder**

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ca	Tot
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA		

**APPLICABLE REQUIREMENTS:**

ASTM-B241-02-STENCILED    ASTM-B221-02    ASME-SB241 1998 SECT II    AMS-QC-A-100-B TYPE  
ASTM-B345-02    UNS#96061    (T6511 also conforms to T6-not applicable to other temper)

**Miscellaneous Notes**

MANUFACTURED IN USA    MELTED IN USA

**CERTIFICATION**

Kaiser Aluminum & Chemical Corp. ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specification forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

Frank E. Watson, Quality Assurance Manager

*Frank E. Watson*

Plant Serial: 10156820  
Kaiser Order Number: 993166

AT 1.188 733